

Date: Monday, 02/06/2008 4:32:18 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR BRACKET
Job Number :	39636A01		
Estimate Number :	10143		
P.O. Number :		Part Number :	D20135
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2013 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	36919A	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	JUP 08.6.02	Due Date :	10/06/2008
Comment :	Est Rev:A New Issue 05-11-01 JLM	Qty:	5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M107688

SB 08/06/23 (5)

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-5.
- 4-Deburr as required

SB 08/06/23 (5)
 SP 08/07/07 (5)
 FF 08-08-01 (5)
 CP 08/07/07 (5)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SO 08/06/05 (X5)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

CARL (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 39636A01

Part Number: D20135

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

AD 08/05/08

Job Completion



MF 08-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

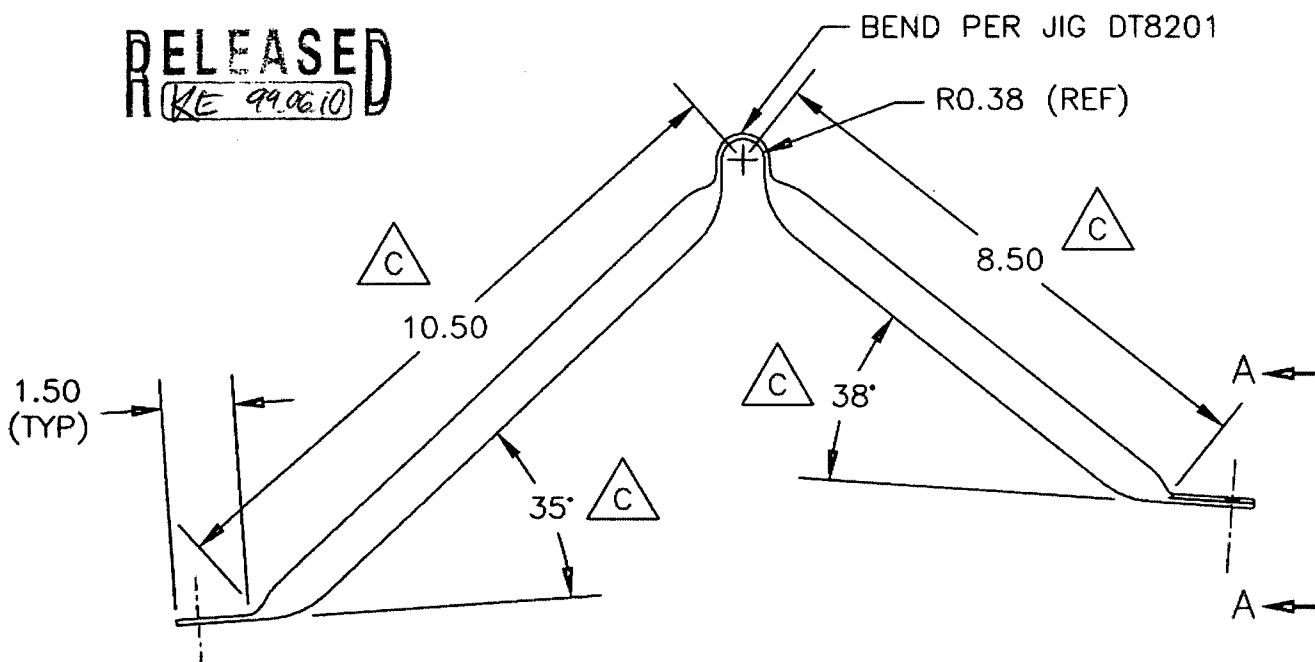
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

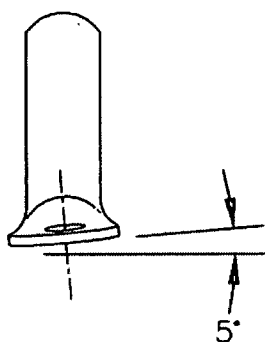
RELEASED
KE 99.06.10

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
0.400 (TYP)



VIEW A-A

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

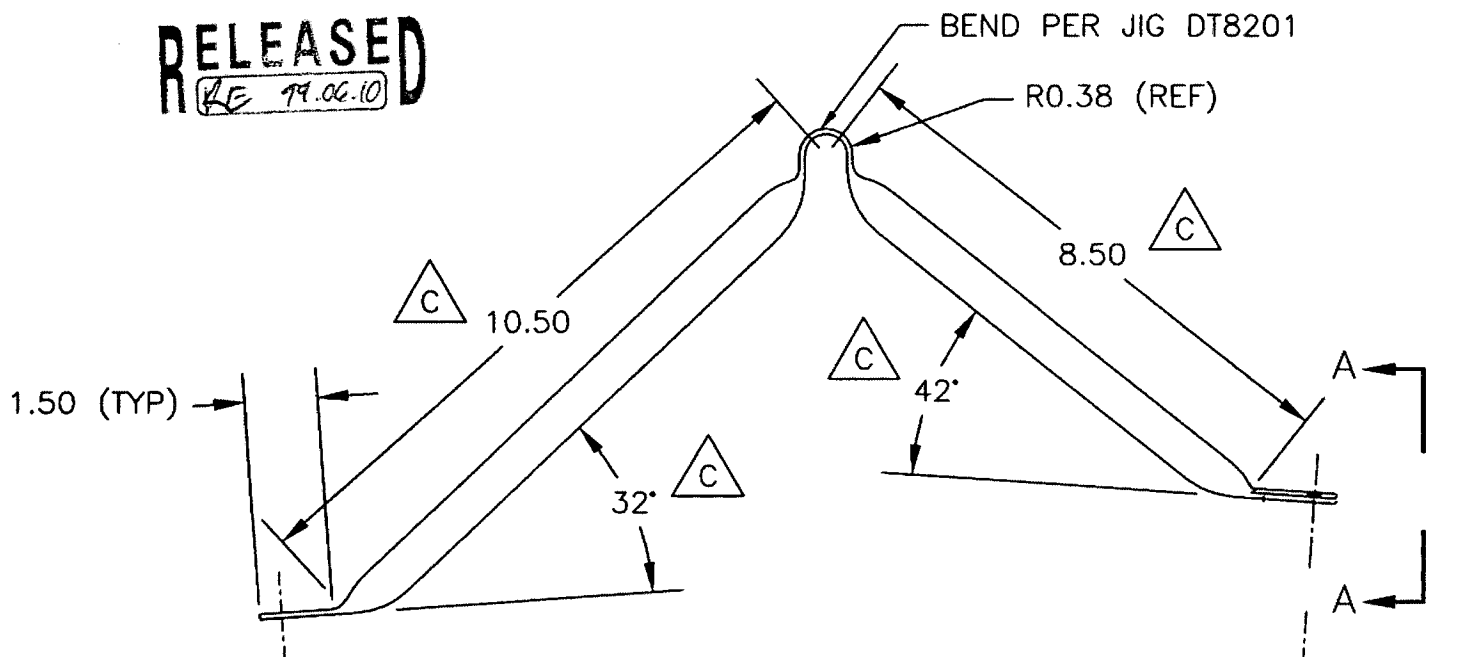
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JB	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED JD	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	REV. C SHEET 1 OF 3
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
SCALE NTS		

RELEASED
RE 79.06.10

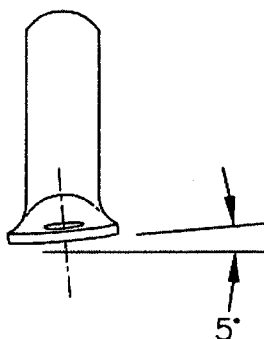
DART



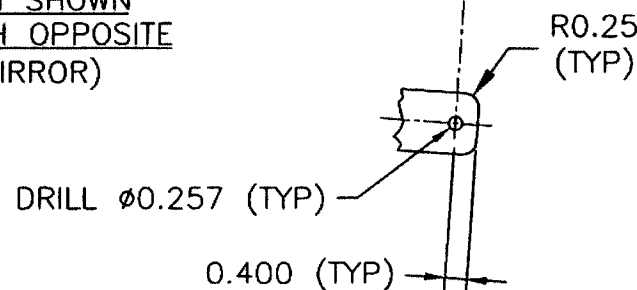
DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	REV. C
DATE	99.06.07	DRAWING NO.	D2013	SHEET 2 OF 3
TITLE	MIRROR BRACKET	SCALE	NTS	



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

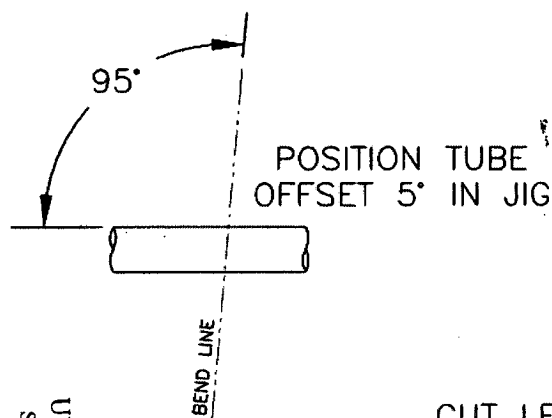
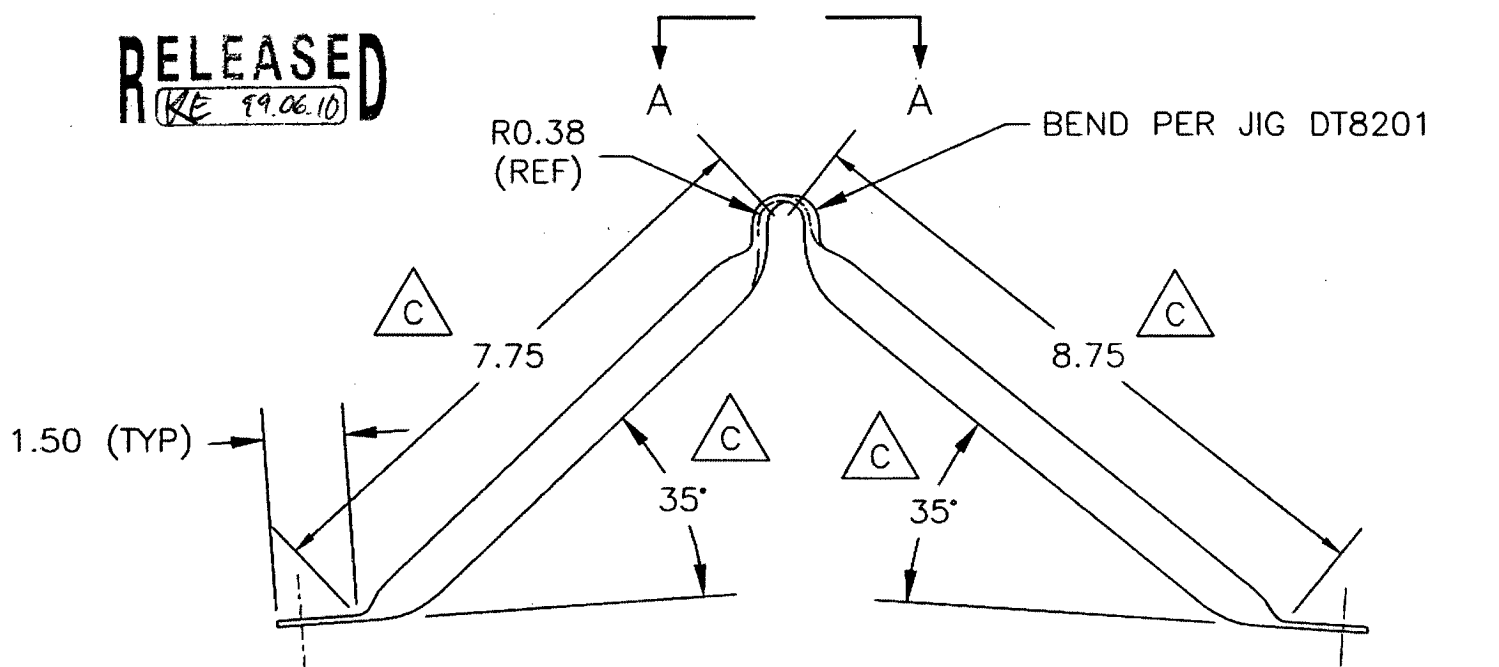
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

RELEASED
(KE 99.06.10)

DART



DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED	KE	APPROVED	KE	DRAWING NO.	SHEET 3 OF 3
DATE	99.06.07			D2013	SCALE
				TITLE	NTS
				MIRROR BRACKET	



POSITION TUBE
OFFSET 5° IN JIG

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\phi 0.257$ (TYP)
0.400 (TYP)
R0.25 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

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WITHOUT NOTICE